



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**RBE350A93-3303-02**

**Job Sheet 196103**



**Part No:** RBE350A93-3303-02

**Job Qty:** 9 pcs

**Part Name:** Tail Rotor Head Body Extractor Tool



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 6/6/19

**Job Tracking No:**

**Due Date:** 7/5/19

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:** SIOP

**Note:** RBE350A93-3303-02 REV 5 IPP REV A 18-01-17 NEW ISSUE JFC VERIFIED DP

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off  |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-----------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |           |
| 100   | Small Fab - 1               | 9 pcs | 7/5/19     |          | 0.08      | 9.00    | Small Fab - 1         |           | <i>ML</i> |
|       |                             |       |            |          |           |         | Small Fab - 2         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |           |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |           |
| 110   | QC 5                        | 9 pcs | 7/5/19     |          | 0.00      | 0.00    | QC 5 - 10             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |           |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |           |
| 130   | Packaging 3-1 - Stock - B4B | 9 pcs | 7/5/19     |          | 0.00      | 0.00    | QC 5 - 9              |           |           |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |           |
|       |                             |       |            |          |           |         | QC 5 - 40             |           |           |
|       |                             |       |            |          |           |         | Packaging 3 - 1 - B4B |           |           |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |           |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |           |
|       |                             |       |            |          |           |         | Packaging 3 - 4 - B4B |           |           |
|       |                             |       |            |          |           |         | Packaging 3 - 5 - B4B |           |           |
|       |                             |       |            |          |           |         | Packaging 3 - 6 - B4B |           |           |
|       |                             |       |            |          |           |         | Packaging 3 - 7 - B4B |           |           |



**Container No:** S191505



**Part:** RBE350A93-3303-02

**Job No:** 196103

**Serial No/Batch:** S191505

**Revision:** 5

**Inspector:**

**Exp Date:**

**Instructions:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 06/18/19

Plex 6/18/19 7:24 AM dart.boucher.sylvie

|                |       |        |      |      |                        |  |
|----------------|-------|--------|------|------|------------------------|--|
|                |       |        |      |      | Packaging 3 - 8 - B4B  |  |
|                |       |        |      |      | Packaging 3 - 9 - B4B  |  |
|                |       |        |      |      | Packaging 3 - 10 - B4B |  |
|                |       |        |      |      | Packaging 3 - 11 - B4B |  |
|                |       |        |      |      | Packaging 3 - 12 - B4B |  |
|                |       |        |      |      | Packaging 3 - 13 - B4B |  |
|                |       |        |      |      | Packaging 3 - 14 - B4B |  |
|                |       |        |      |      | Packaging 3 - 15 - B4B |  |
|                |       |        |      |      | Packaging 3 - 16 - B4B |  |
|                |       |        |      |      | Packaging 3 - 17 - B4B |  |
|                |       |        |      |      | Packaging 3 - 18 - B4B |  |
|                |       |        |      |      | Packaging 3 - 19 - B4B |  |
|                |       |        |      |      | Packaging 3 - 20 - B4B |  |
|                |       |        |      |      | Packaging 3 - 21 - B4B |  |
|                |       |        |      |      | Packaging 3 - 22 - B4B |  |
|                |       |        |      |      | Packaging 3 - 23 - B4B |  |
|                |       |        |      |      | Packaging 3 - 24 - B4B |  |
|                |       |        |      |      | Packaging 3 - 25 - B4B |  |
|                |       |        |      |      | Packaging 3 - 26 - B4B |  |
|                |       |        |      |      | Packaging 3 - 27 - B4B |  |
|                |       |        |      |      | Packaging 3 - 28 - B4B |  |
|                |       |        |      |      | Packaging 3 - 29 - B4B |  |
|                |       |        |      |      | Packaging 3 - 30 - B4B |  |
|                |       |        |      |      | Packaging 3 - 31 - B4B |  |
|                |       |        |      |      | Packaging 3 - 32 - B4B |  |
|                |       |        |      |      | Packaging 3 - 33 - B4B |  |
|                |       |        |      |      | Packaging 3 - 34 - B4B |  |
|                |       |        |      |      | Packaging 3 - 35 - B4B |  |
|                |       |        |      |      | Packaging 3 - 36 - B4B |  |
| 140 QC 21 - FG | 9 pcs | 7/5/19 | 0.00 | 0.00 | QC 21 - FG - 21        |  |
|                |       |        |      |      | QC 21 - FG - 70        |  |
|                |       |        |      |      | QC 21 - SA - 53        |  |

DARA  
DAS  
21  
JUN 19 2019

GA143A

Part Op **100** - (Small Fab) - Assemble as per DWG. Sheet 1 - Loctite 262/263 B 1138904 Exp: 4/20  
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)  
**130** - (Identify as per dwg & Stock Location: \_\_\_\_\_)  
**140** - (QC21- Final Inspection - Work Order Release)

### Job BOM

| Part / Item            | Component Name | Quantity      | Operation         | Container           |
|------------------------|----------------|---------------|-------------------|---------------------|
| 91030A031              | Flange Hex Nut | 18 Ea (2 ea)  | 100-Small Fab - 1 | <del>5172645</del>  |
| RBE350A93-3303-02-1    | Receiver       | 9 pcs (1 ea)  | 100-Small Fab - 1 | 11389780 5183991    |
| RBE350A93-3303-02-3    | Extractor      | 9 pcs (1 ea)  | 100-Small Fab - 1 | 5183993             |
| RBE350A93-3303-02-5-PO | Extractor Pin  | 9 pcs (1 ea)  | 100-Small Fab - 1 | 415076184 515079438 |
| RBE350A93-3303-02-7    | Stud           | 18 pcs (2 ea) | 100-Small Fab - 1 | 5181653             |

### Job Allocations

| Operation         | Component Part      | Required | Inventory | Allocated |
|-------------------|---------------------|----------|-----------|-----------|
| 100-Small Fab - 1 | 91030A031           | 18       | 49        | 0         |
|                   | RBE350A93-3303-02-1 | 9        | 9         | 0         |
|                   | RBE350A93-3303-02-3 | 9        | 10        | 0         |
|                   | RBE350A93-3303-02-5 | 9        | 42        | 0         |
|                   | RBE350A93-3303-02-7 | 18       | 42        | 0         |

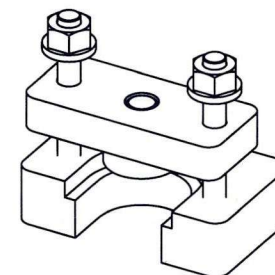
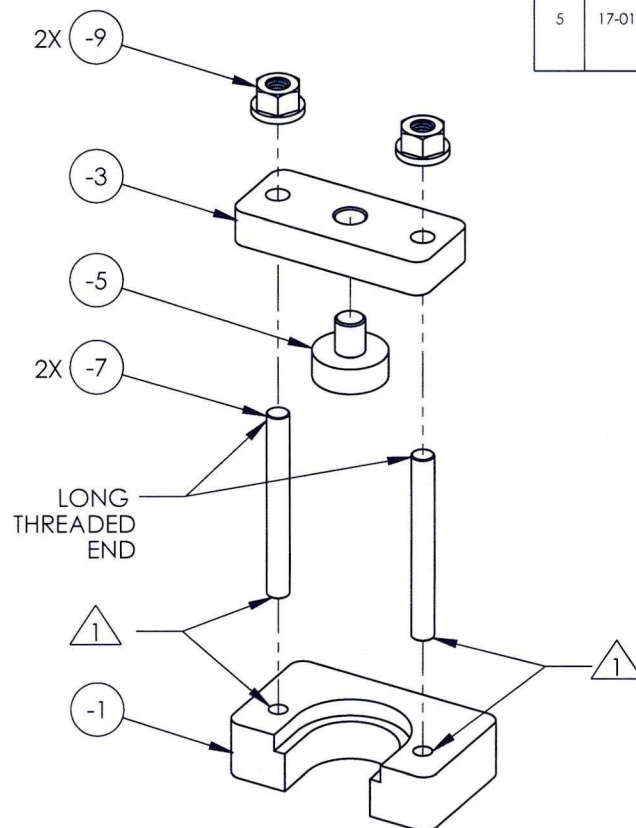
### Part Specifications

Specifications could not be found.



This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

| REVISIONS |         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |           |         |          |
|-----------|---------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|---------|----------|
| REV       | ECR     | DESCRIPTION                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | DATE      | INITIAL | APPROVED |
| 1         |         | CH'D FROM HEX BOLTS & SET SCREWS TO STUDS. -1 ADDED R.25 TO CORNERS. -3 CH'D HOLES FROM Ø.413 AND ADDED R.25 TO CORNERS.                                                                                                                                                                                                                                                                                                                                                                                                                                           | 12/4/2008 | WP      | DW       |
| 2         |         | -11 ADDED LOCTITE TO BOM. -5 ADDED .03 X 45° CHAMFER.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 12/4/2008 | WP      | DW       |
| 2A        |         | CORRECTED T/N AND TOOL NAME WAS RBEA93-3303-02, T/R HUB BODY EXTRACTOR TOOL IS RBE350A93-3303-02, T/R BODY EXTRACTOR TOOL.                                                                                                                                                                                                                                                                                                                                                                                                                                         | 11/5/2013 | RJC     | RW       |
| 3         |         | -3 CH'D DIMS WAS Ø.500 IS LIMITS Ø.5000 - .5005, WAS .630 IS (.625). -5 CH'D DIM WAS Ø.501 IS Ø.5010 - .5015. -9 CH'D WAS SWIVEL HEX NUT #90477A031 IS FLANGE HEX NUT #91030A031.                                                                                                                                                                                                                                                                                                                                                                                  | 3/13/2014 | DPD     | GE       |
| 4         | 15-0132 | -1 & -3 CH'D MATERIAL WAS 1018 IS A36/1018/1020. -5 CH'D MATERIAL WAS 4140 G&P IS 4140/4142 Q&T.                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 6/10/2015 | RJC     | JAG      |
| 5         | 17-0169 | CH'D NOTE 1 WAS 2X LOCTITE ON THREADS -7 TO -1 IS LOCTITE 262 OR EQUIVALENT ON THREADS -7 STUD TO -1 RECEIVER. -1 CH'D MAT'L WAS A36/1018/1020 IS A36/1018/1020 HR. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. CH'D DIM WAS 2.350 IS 2.35. -3 CH'D MAT'L WAS A36/1018/1020 IS A36/1018/1020 HR. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. -5 CH'D MAT'L WAS 4140/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. -7 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. CH'D DIM WAS .63 IS .7. -11 DELETED 262 LOCTITE FROM BOM. | 7/13/17   | DPD     | JAG      |



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 196103 MJS  
1906-06

NOTE:

- 1 LOCTITE 262 OR EQUIVALENT ON THREADS -7 STUD TO -1 RECEIVER.

|                                         |                                                                                                                                            |
|-----------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------|
| <b>DART<br/>AEROSPACE</b>               |                                                                                                                                            |
| TITLE<br><b>T/R BODY EXTRACTOR TOOL</b> |                                                                                                                                            |
| DWG NO.<br><b>RBE350A93-3303-02</b>     | REV<br><b>5</b>                                                                                                                            |
| MAT'L<br>HEAT TREAT<br>FINISH<br>SPEC   | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>.XXX ± .005 FRACTIONS ± 1/8<br>.XX ± .01 ANGLES ± 5°<br>.X ± .1 SURFACES = 125/✓ |
| DRAWN BY: PERRITT                       | 1. BREAK ALL SHARP EDGES<br>.015 x 45° OR .015R                                                                                            |
| CHECKED: RJC 07/13/2017                 | 2. DIMENSIONAL LIMITS APPLY<br>AFTER PLATING                                                                                               |
| OPPS APPR: AA 07/21/2017                | 3. INTERPRET DIM AND TOL PER<br>ASME Y14.5M-2009                                                                                           |
| QA APPR: JL 07/24/2017                  | USED ON MODEL                                                                                                                              |
| APPROVED: JAG 07/26/2017                | EUROCOPTER AS350A                                                                                                                          |
| SCALE 1:3                               | DATE 10/27/2008 SHEET 1 OF 5                                                                                                               |

| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description    | Material         | B/O INFORMATION OR SPECIFICATIONS                     | PG. |
|----------|----------|-----|--------|----------|----------------|------------------|-------------------------------------------------------|-----|
|          |          |     | -1     | 1        | RECEIVER       | A36/1018/1020 HR |                                                       | 2   |
|          |          |     | -3     | 1        | EXTRACTOR      | A36/1018/1020 HR |                                                       | 3   |
|          |          |     | -5     | 1        | EXTRACTOR PIN  | 4140/4142        |                                                       | 4   |
|          |          |     | -7     | 2        | STUD           | STEEL            | 3/8-16 UNC-2A X 4 (MCMASTER-CARR #90281A640) MODIFIED | 5   |
|          |          | B/O | -9     | 2        | FLANGE HEX NUT | STEEL            | 3/8-16 UNC-2B (MCMASTER-CARR #91030A031)              | 1   |